

Work Order ID 65717



Monday, January 24, 2011 12:46:26 PM

Page 1

Item ID: D2892-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 1/24/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 2/24/2011 Req'd Qty: 14.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 1-01-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2892

Rev A

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

OK 11/03/08

6 0

HAAS CNC vertical machine #1

Machine as per Folio FA082 Tumble & Deburr

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

OK 11/03/08

6 0

Quality Control

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

1. A 11/03/09

6 0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

Required Date: 2/24/2011 Req'd Qty: 14.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

M 115951

Memo

0.00

Powder Coating

START TIME:

11:50

DOVEN TEMPERATURE:

FINISH TIME:

12:06

6 BR 11-3-10

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11/3/10 sf (62)

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11/3/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 65717

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Page 3

Item ID: D2892-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Support

Start Date: 1/24/2011 Start Qty: 14.00



Cust Item ID:

Required Date: 2/24/2011 Req'd Qty: 14.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/10 [Signature]
R 11-03-10
C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, January 24, 2011 12:46:36 PM

Page 1

Work Order ID: 65717

Parent Item: D2892-1

Parent Item Name: Support




Start Date: 1/24/2011

Required Date: 2/24/2011

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP C02.11.26 Added P/O KJ
IPP D 08.03.19 Re-format EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK077 		Manufactured	No			110	Each	3.0000	0.5	7			
D2892-1 TURNING DETAIL													

Location

Loc Qty

Loc Code

MAT

3

56045

3

3 *2/14/03/03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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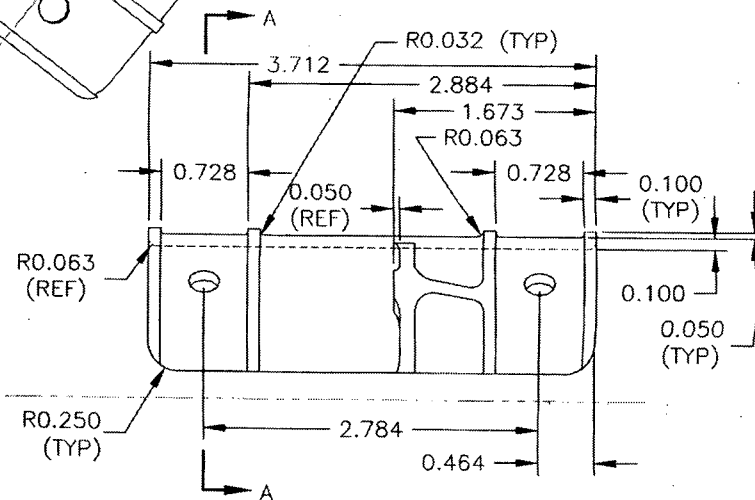
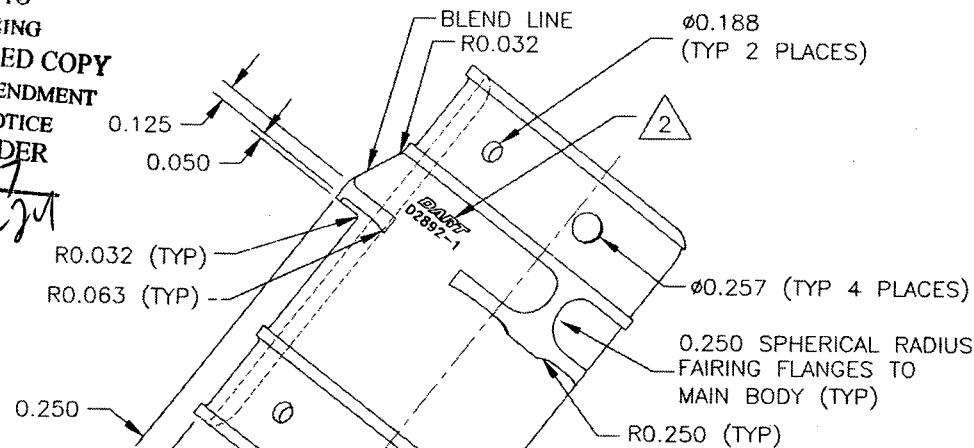
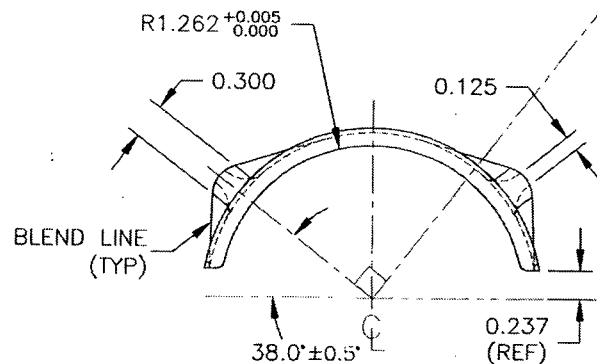
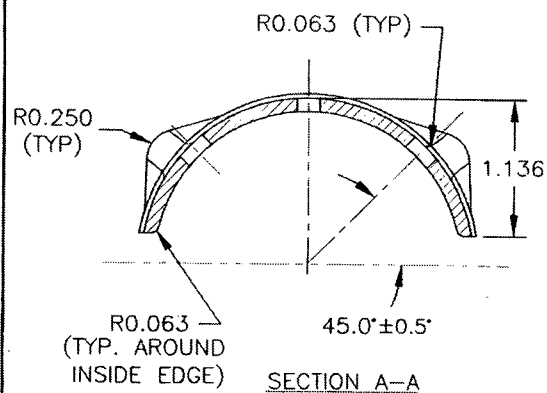
NOTE: Date & initial all entries

D2892-1

- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
- 2) IDENTIFY WITH DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
- 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 (REF. X.XXX = ± 0.010) UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *65717*

pld-1-24



A		00.11.17	NEW ISSUE
DESIGN <i>GP</i>		DRAWN BY <i>GP</i>	DART DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED <i>GP</i>		APPROVED <i>GP</i>	DRAWING NO. D2892
DATE 00.11.17		TITLE Ø2.500 SUPPORT	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		REV. A SHEET 1 OF 1 SCALE 1:1	

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DART AEROSPACE LTD		Work Order:	65717
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.115	0.135	Vern M1-7	.131	.131	.130	.131	.130
AB	0.290	0.310	"	.310	.310	.310	.310	.310
AC	0.040	0.060	"	.045	.045	.055	.055	.050
AD	0.115	0.135	"	.125	.125	.125	.125	.125
AE	0.240	0.260	"	.257	.257	.246	.246	.247
AF	0.188	0.193	"	.191	.191	.191	.191	.191
AG	0.240	0.260	Rad-gage	.250	.250	.250	.250	.250
AH	1.126	1.146	High gage 31006	1.143	1.141	1.143	.141	1.140
AI	0.454	0.474	Vern M1-7	.469	.469	.461	.460	.462
AJ	0.240	0.260	Rad-gage	.250	.250	.250	.250	.250
AK	0.053	0.073	"	.063	.063	.063	.063	.063
AL	0.257	0.262	Vern M1-7	.262	.262	.262	.262	.262
AM	1.663	1.683	"	1.675	1.675	1.675	1.675	1.677
AN	0.053	0.073	Rad-gage	.063	.063	.063	.063	.063
AO	0.022	0.042	"	.032	.032	.032	.032	.032
AP	2.779	2.789		2.782	2.782	2.781	2.781	2.782
AQ								
AR								
AS								
AT								
Accept/Reject								

Measured by: OMK Date: 11/03/08

Audited by: HA Date: 11/03/09

Prototype Approval: _____ Date: _____


Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	08.04.21	Reformat	KJ/JLM	

DART AEROSPACE LTD		Work Order:	65717
Description: Ø2.500 Support		Part Number:	D2892-1
Inspection Dwg: D2892		Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

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AF	0.188	0.193		.191				
AG	0.240	0.260		.250				
AH	1.126	1.146		1.138				
AI	0.454	0.474		.462				
AJ	0.240	0.260		.250				
AK	0.053	0.073		.063				
AL	0.257	0.262		.262				
AM	1.663	1.683		1.677				
AN	0.053	0.073		.063				
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AP	2.779	2.789		2.782				
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Measured by:  Date: 11/03/08

Audited by: K.A. Date: 11/03/09

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